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D4171-1
Job Sheet 187915



Part No: D4171-1

Job Qty: 20 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	20 pcs	1/11/19	1/11/19	0.00	3.99	Doosan - 1	
140	QC 8	20 pcs	1/11/19	1/11/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 38	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
200	Packaging 3-1 - Stock - B4B	20 pcs	1/11/19	1/11/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
210 QC 21 - SA	20 pcs	1/11/19	0.00 0.00		

Part Op 100 - (Doosan Lathe) 1-Turn as per Dwg & Folio FA963
 Descriptions: 140 - (QC8- Inspect parts - second check)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

JAN 09 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	1.6000 ft (.08 ea)	100-Doosan - 1	S123402 21"

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R1.000	2	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.750Inches ± 0.010	0.760 0.740	.75	
2	Bushing	0.540Inches ± 0.010	0.550 0.530	.541	
3	Bushing	0.210Inches ± 0.010	0.220 0.200	.2095	
4	Bushing	0.150Inches ± 0.010	0.160 0.140	.1495	
5	Bushing	0.305Inches + 0.000 - 0.002	0.305 0.303	.3046	Diameter
6	Bushing	0.010Inches ± 0.010	0.020 0.000		Radius R.015
7	Bushing	0.060Inches ± 0.010	0.070 0.050	.06	
8	Bushing	0.395Inches + 0.015 - 0.005	0.410 0.390	.391	
9	Bushing	0.563Inches + 0.002 - 0.015	0.565 0.548	.5573	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			

10	Bushing	0.880Inches $\pm$ 0.030	0.910 0.850	<i>.8795</i> Diameter
11	Bushing	0.191Inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.196 0.190	<i>.1925</i> Diameter
12	Bushing	0.063Inches $\pm$ 0.010	0.073 0.053	<i>R1/6</i> Radius
13	Bushing	0.060Inches $\pm$ 0.010	0.070 0.050	<i>.06</i> Radius
14	Bushing	45.000Degrees $\pm$ 0.500	45.500 44.500	<i>45°</i> Angle
15	Bushing	0.023Inches $\begin{matrix} + 0.030 \\ - 0.010 \end{matrix}$	0.053 0.013	<i>.045</i>
16	Bushing	0.030Inches $\pm$ 0.010	0.040 0.020	<i>.027</i>
17	Bushing	20.000Degrees $\pm$ 0.500	20.500 19.500	<i>20°</i> Angle

Plex 12/20/18 11:23 AM Dart.lajeunesse.marie

